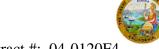
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William **Report No:** WIR-029464 Address: 333 Burma Road **Date Inspected:** 04-May-2013

City: Oakland, CA 94607

Project Name: SAS Superstructure **OSM Arrival Time:** 700 **OSM Departure Time:** 1530 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV Contractor: American Bridge/Fluor Enterprises, a JV **Location:** Job Site

CWI Name: Bernie Docena **CWI Present:** Yes No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No **Weld Procedures Followed:** Yes No N/A **Qualified Welders:** Yes No N/A **Verified Joint Fit-up:** Yes No N/A N/A Yes No N/A **Approved Drawings:** Yes No **Approved WPS:** Yes No N/A **Delayed / Cancelled:**

34-0006 **Bridge No: Component: SAS** Tower

Summary of Items Observed:

Caltrans Quality Assurance Inspector (QA) Joe Adame was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel.

In Process Visual Inspection

RWR201304-013

ESW "N"-Face B

The QA Inspector observed, at random intervals, ABF/JV welder Mike Jimenez (WID-4671) performing weld repairs of the R2 repair excavation on Electroslag Weld (ESW) "N", at face B original Y location 5190mm. Locations are listed as detailed in Request for Weld Repair (RWR) 201304-013 from Ultrasonic Testing indications designated for repair. Prior to the repair work, ABF Quality Control (QC) Inspector Bernie Docena and the QA Inspector performed a preliminary MT verification of in-process weld passes to verify the weld was clear of any discontinuities that may have occurred during cooling overnight. The repair area will be reinspected after welding any indications noted will be revaluated. The welder was observed preheating the weld to over 300° Fahrenheit prior to welding using the Miller ProHeat 35 with heat induction blankets. The welder utilized ABF Welding Procedure Specification (WPS) ABF-WPS-D15-1000-Repair Rev.3 for Shield Metal Arc Welding (SMAW). The welding parameters were verified by QC Inspector Bernie Docena throughout the day and appeared to be in compliance with the WPS noted above. See TL-6028 for information on items inspected.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

Only general conversations with ABF/JV QC NDT personnel relevant to testing and work performed during this shift.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Adame, Joe	Quality Assurance Inspector
Reviewed By:	Mertz,Robert	QA Reviewer